

Work Order ID 73398

Wednesday, August 31, 2011 3:04:55 PM



Page 1

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 8/31/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/08/11 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2230	Rev G								

100

Bandsaw
Jeaspa Bandsaw

BAND SAW

0.00

Memo
Cut D2423 extrusion to 0.82"
Batch: _____

CL 11/09/01

110

HAAS 1 purch
HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo
1-Machine per folio FA927
DWG REV: _____
FOLIO REV: _____
(Check for crack while loading into the machine.)
2- deburr rough edges

CL 11/09/01 100

issue P/O to metec P/O: 14799

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120 *rec'd*

~~QC2~~ Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

*rec'd + inspect for transit damage.
attached cagc to wio.*

Rec'd 8/31/11 (140)

130

~~QC2~~ Inspect parts - second check

0.00



QC

Quality Control

Memo

0.00

Scrub

*counts
140
25019*

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Hand Finishing

Memo

0.00

*140 X 8 M / 11/10/12
Counted*

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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

140R d JH 11/14/14
count

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

0.00

140 x 8 M-F 11/10/14

170

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

140 d JH 10/1/14
count

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Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: 480

0.00



Packaging

Memo

0.00

Packaging

11/10/17 140

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/18
MF
11-10-18

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 31, 2011 3:04:52 PM

Page 1

Work Order ID: 73398

Parent Item: D2230-1

Parent Item Name: Lug



Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP ☐ D00.11.01 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No			110	f	538.5000	0.0683	7.189474			
-------	--	--------------	----	--	--	-----	---	----------	--------	----------	--	--	--



Lug Extrusion



CL 11/09/01

Location

Loc Qty

Loc Code

MAT006

538.5

43722

161.5

45800

1

68331

376

7.19

D2230-1P

X 100

Rec'd 11/14 (190)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

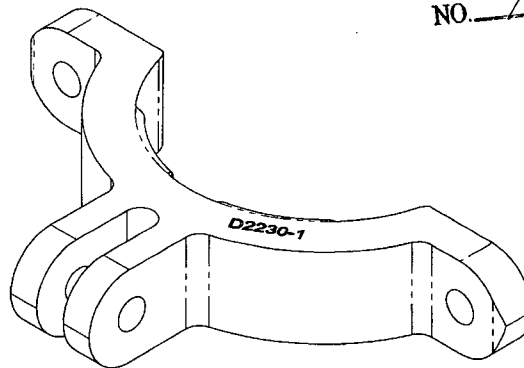
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

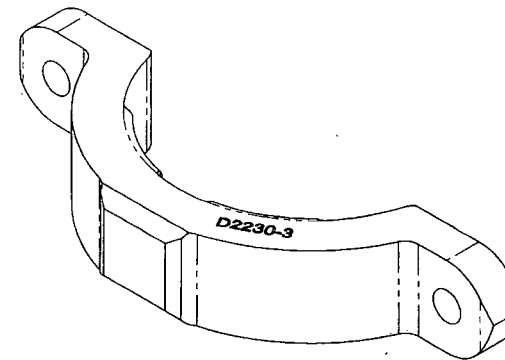
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73378



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
9/16/16



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

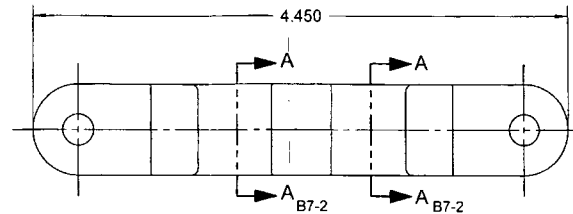
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

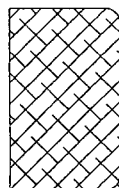
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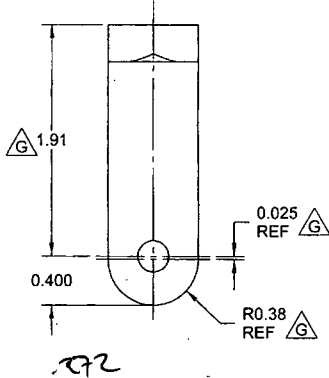
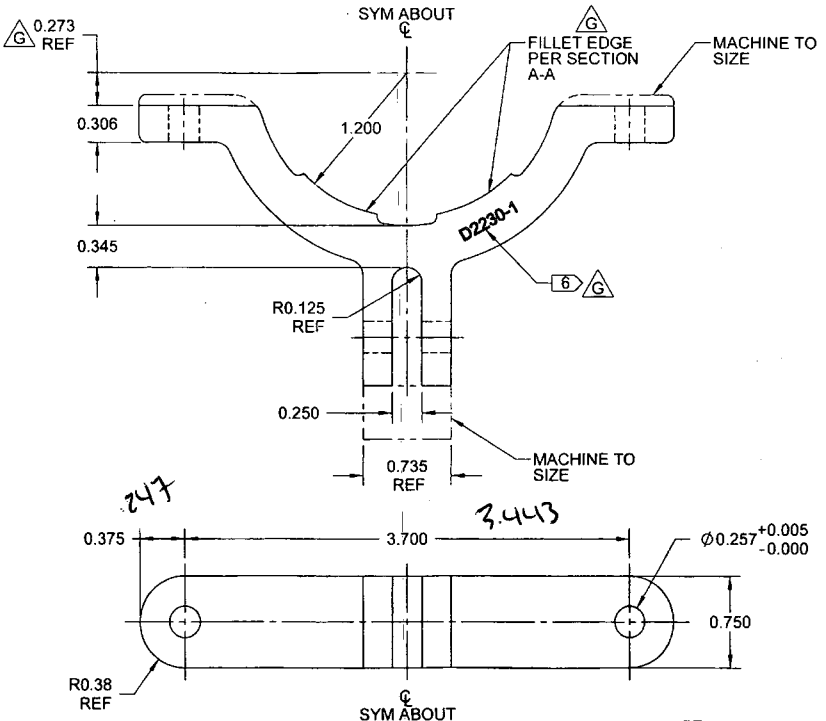


120



SECTION A-A D4-2
SCALE 2X

R0.06 MIN - R0.10 MAX
2 PL



D2230-1 MOUNTING LUG

RELEASED
09/06/25/11

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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NOTE: Date & initial all entries

8

7

6

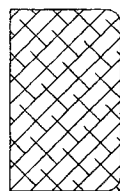
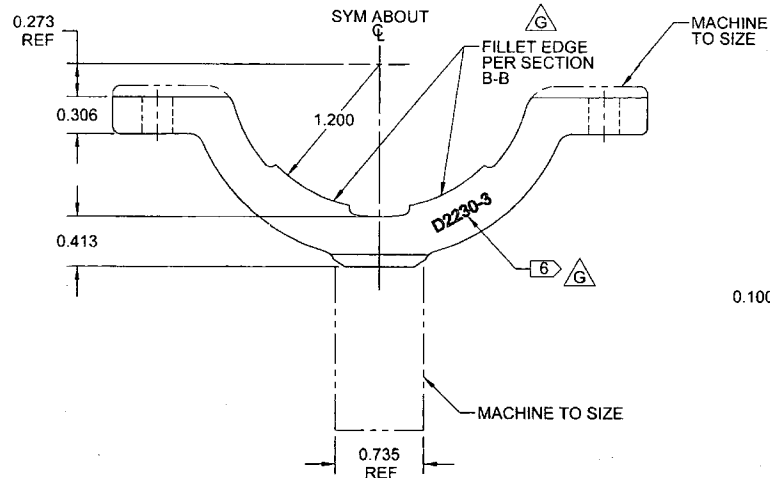
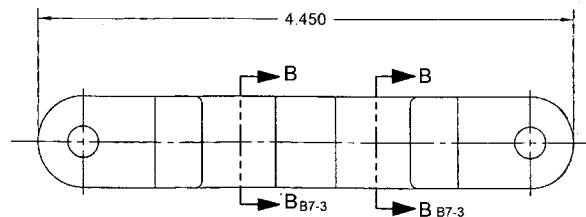
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4

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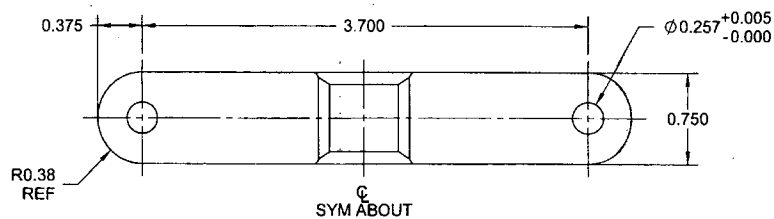
2

1





SECTION B-B D4-3
SCALE 2X

R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/2016

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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8

7

6

5

4

3

2

1

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NOTE: Date & initial all entries



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18166
Date: Oct 04, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 14799	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Oct 04, 2011

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-3 Mounting Lug Material supplied by DART: D2423 B68331	Each	80		80
D2230-1 Mounting Lug Material supplied by DART: D2423 B68331	Each	100	140	
D2230-3 Mounting Lug Material supplied by DART: D2423 B68331	Each	200		
D3235-1 Mounting Lug Material supplied by DART: D2423 B68331	Each	100	106	
D3394-1 Lug Assembly Material supplied by DART: D2423 B68331	Each	40		
D3910-1 Crosstube Lug Material supplied by DART: D2423 B68331	Each	30		
3910-3 Crosstube Lug Material supplied by DART: D2423 B68331	Each	30		
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		

CERTIFICATE OF CONFORMITY

SOLD TO: 

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

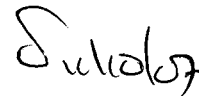
PART NAME

P.O. NUMBER

140

D2230-1


Mounting Lug



14799

MATERIAL: supplied by DART D2423 B68331

106

 D3235-1

Mounting Lug

14799

MATERIAL supplied by Dart D2423 B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris



Vankleek Hill, October 4, 2011